

Draw #56199

Work Order ID 53048

October 22, 2009 11:27:38 AM



Item ID: D3883-1
 Revision ID: B
 Item Name: Saddle, Outboard LH
 Start Date: 21/10/2009 Start Qty: 4.00
 Required Date: 30/10/2009 Req'd Qty: 4.00

8. J. J.



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: RP Date: 04-10-22 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3883	B								

100



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

4

Ø

Memo

Program Batch No. B53048
 Double check by: WWE

0.00

M.A 10/01/30

- 1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets

110



QC

Quality Control

QC2- Inspect parts off machine FA1/FAIB

0.00

4

Ø

Memo

0.00

M.A 10/01/30

Dart Aerospace Ltd

W/O: ✓		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 13883-1 PAR #: _____ Fault Category: Machined parts NCR: (Yes) No DQA: 7 Date: 10.03.01
 Resolution: Accepted Disposition: Use as is. QA: N/C Closed: _____ Date: _____

NCR: <u>53048</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.02.01	100	FLANGE THICKNESS IS 0.003 UNDER TOL. SADDLE-TU-SKID THICKNESS IS 0.002* UNDER TOL. Re: process	CP 10.02.02 per Q51042	Acceptable.	M.A 10/02/01	7 10.02.03	CP 10.02.02 per Q51042	7 10.02.05

NOTE: Date & initial all entries

Work Order ID 53048

October 22, 2009 11:27:38 AM



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Item ID:	D3883-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Saddle, Outboard LH					
Start Date:	21/10/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 SA 10/02/05 0.00				4	6		
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 BL 10-02-8 0.00				4	8		
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005.4.3-Alum 11113170 Memo START TIME: 10:30AM OVEN TEMPERATURE: 320°F FINISH TIME: 11:00AM	0.00 => JH 10/02/08 0.00				4	8		

Work Order ID 53048

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October 22, 2009 11:27:38 AM

Item ID: D3883-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, Outboard LH

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00

BH 10-02-8

(4)

φ



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: 429

0.00



Packaging

Memo

0.00

Packaging

Rec'd 11/11 (4)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/16

unf

10-2-11

Picklist Print

Page 1

October 22, 2009 11:27:43 AM

Work Order ID: 53048



Parent Item: D3883-1RevB



Parent Item Name: Saddle, Outboard LH

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-015RevB		Manufactured	No			100	Each	20.0000	4.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MACHINING

51834

20

20

4

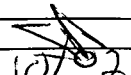
M.A 10/01/30


DART AEROSPACE LTD		Work Order:	
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883	Rev. C	Page 1 of 1	

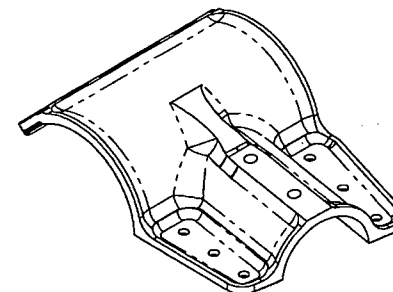
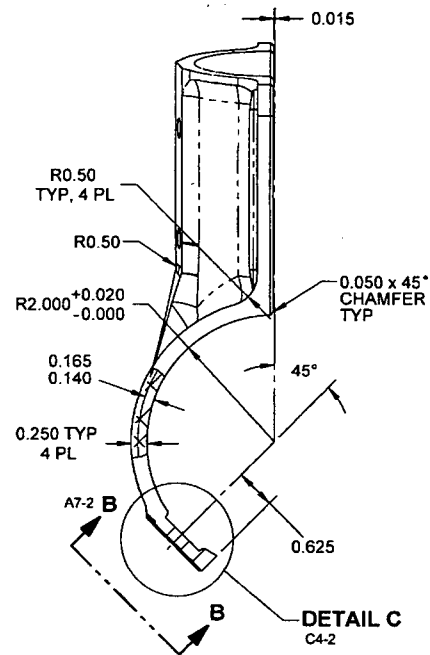
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.876	2.876	2.876	2.876		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.646	0.647	0.647	0.648		
D	3.895	3.905		3.901	3.900	3.900	3.901		
E	0.257	0.262		0.260	0.260	0.260	0.260		
F	0.605	0.625		0.612	0.617	0.616	0.616		
G	1.120	1.130		1.125	1.126	1.125	1.127		
H	2.245	2.255		2.251	2.251	2.251	2.251		
I	2.000	2.020		2.001	2.002	2.002	2.001		
J	0.140	0.165	*	0.138	0.155	0.154	0.154		
K	0.240	0.260	*	0.237	0.254	0.255	0.256		
L	0.115	0.135	*	0.112	0.125	0.125	0.124		
M	0.140	0.165		0.143	0.152	0.154	0.154		
N	0.720	0.780		0.765	0.770	0.765	0.765		
O	0.240	0.260		0.250	0.249	0.246	0.257		
P	0.110	0.140		0.140	0.140	0.140	0.140		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.870	2.868	2.868	2.868		
S	0.316	0.321		0.321	0.321	0.321	0.321		
T	0.990	1.010		1.0005	1.0040	1.0070	1.0005		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.002	6.002	5.999		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.495	0.498	0.497	0.497		
Y	1.220	1.280		1.260	1.260	1.260	1.260		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.317	0.317	0.317	0.317		
AB	0.020	0.040		0.032	0.032	0.032	0.032		
AC	0.760	0.765		0.764	0.764	0.764	0.764		
AD	0.215	0.220		0.218	0.218	0.218	0.217		
AE	1.265	1.285		1.267	1.267	1.267	1.266		
AF									
Accept/Reject									

Measured by:	K.A.
Date:	10/01/30

Audited by:	
Date:	10/02/30

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	






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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63048

PR 09-102

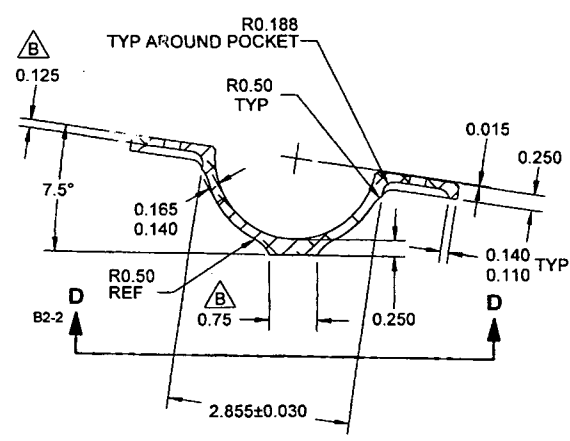
RELEASED
09/07/15

NOTES:

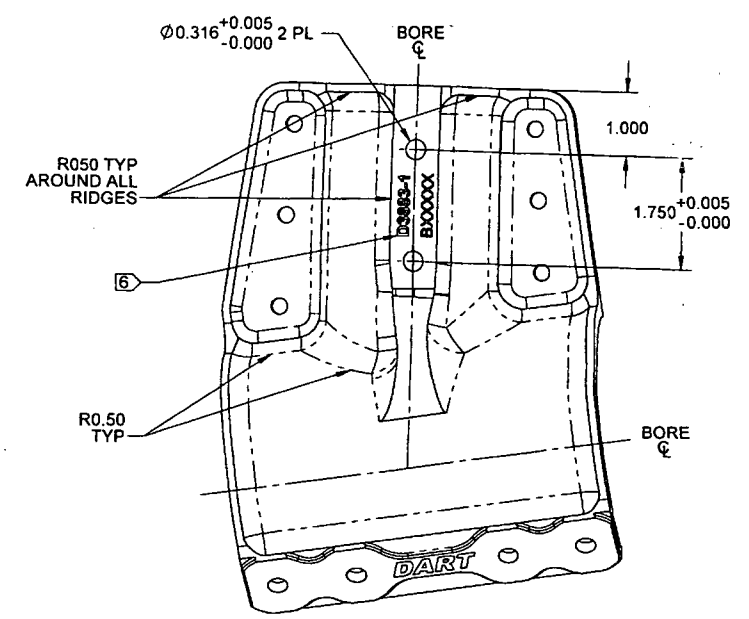
- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D3883	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		OUTBOARD SADDLE		NT
DATE	09.06.30			

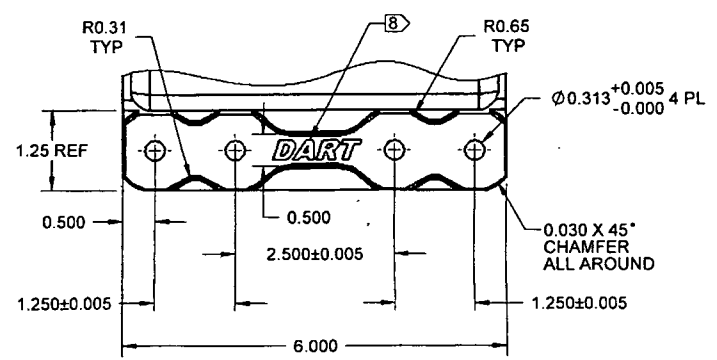
53048



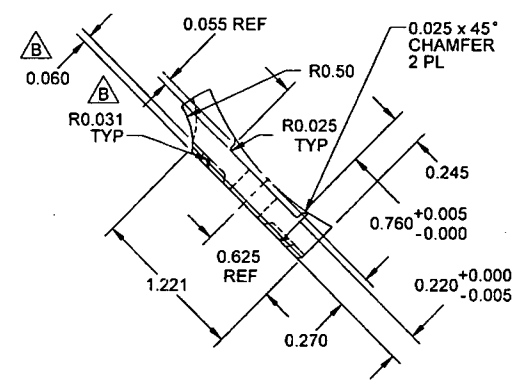
SECTION A-A C7-1



VIEW D-D C7-2



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO. D3883	REV. B
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD SADDLE	NTS
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